

Work Order ID 59578

Tuesday, June 08, 2010 10:38:22 AM



Page 1

Item ID: D3187-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Floor

Start Date: 6/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/11/2010 Req'd Qty: 2.00



Customer:

Reference: NCR 10-010

Approvals: Process Plan: ymk Date: 10-6-8 Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3187	Rev C

200

0.00



Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK D3187-1 B31835

X 2

1- install D2986-1 rubber spacer using contact cement and trim to fit if necessary
as per dwg D3187 A/R contact cement Batch: 112983 2- transfer
holes from spacepod floor to rubber spacerRT 10-06-09

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/66/07

Dart Aerospace Ltd

W/O: 59578		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-06-09	200	instead of using 3187-1 B used 2 x <u>D3187-2</u> <u>B 31836</u>	<i>ET</i>	10-06-09			<i>Sp</i> 10/06/09

Part No: D3187-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference: NCR 10-010

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Identify as per dwg & Stock Location: 241

0.00



Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

(x2) BB 10/06/10

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10 JH
M/10-6-10
(2)

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Picklist Print

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Work Order ID: 59578



Parent Item: D3187-1



Parent Item Name: Spacepod Floor

Start Date: 6/8/2010

Required Date: 6/11/2010

Comments: IPP: C05.04.14 Now a purchased part KJ/JLM
IPP Rev:D Now On Waterjet 07-04-19 JLM
IPP Rev:E Now Powder Coated 07-05-24 JLM
IPP Rev:F 09-01-20 rev.c as per dwg DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

D2986-1

Manufactured No

100

Each

15.0000

1

2



Rubber Spacer



FT 10-06-09

Location

Loc Qty

Loc Code

ST242

15

57659

3

59409

12

x2

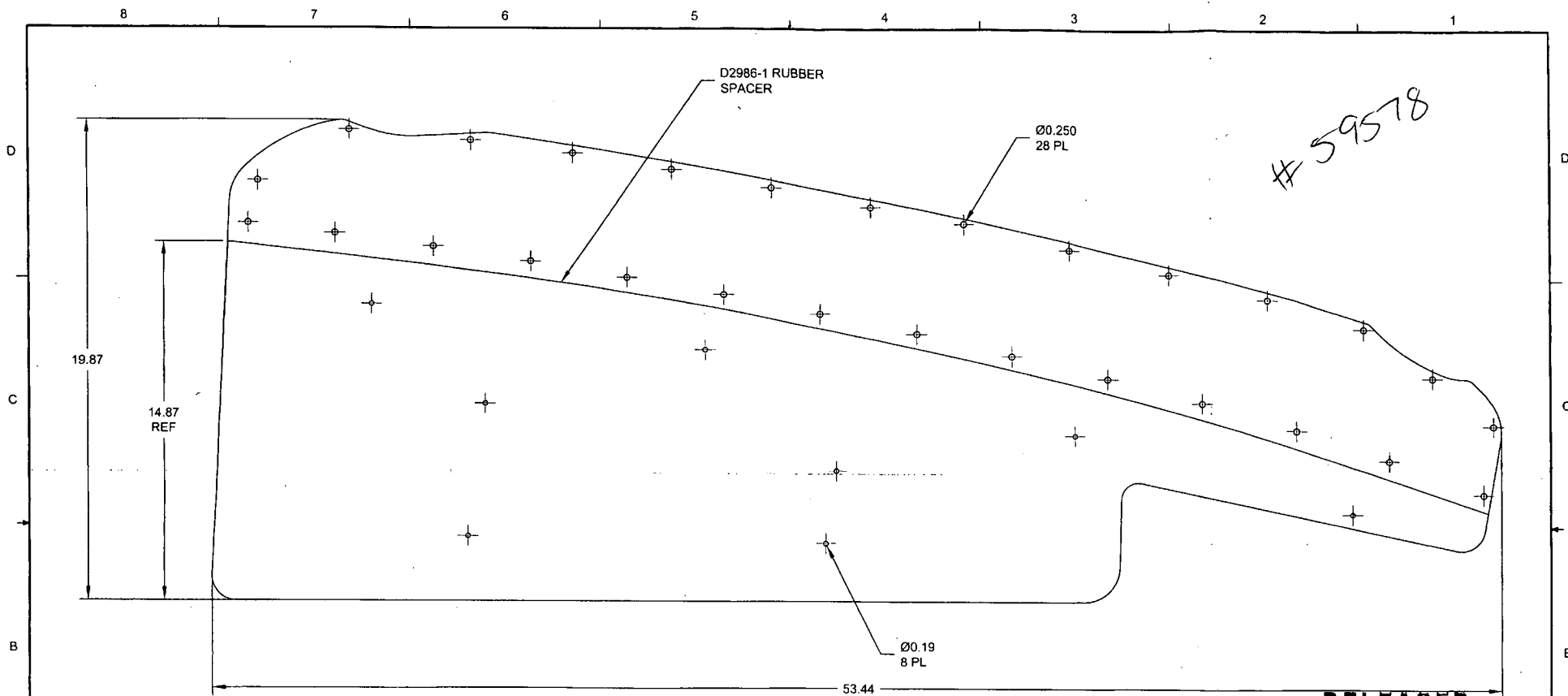
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D3187-1 SPACEPOD FLOOR

RELEASED
09.01.05

D3187-1 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

C	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED SHEET 2; CREATED DETAIL FOR D3187-2; REVISED SHEET 1 NOTES. REASON: CLARIFIED DRAWINGS FOR D3187-1/-2.	MB	09.01.05
B	CHANGE SHAPE	CP	03.05.16
A	NEW ISSUE	CP	03.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3187	REV. C SHEET 1 OF 2
TITLE SPACEPOD FLOOR	SCALE NTS
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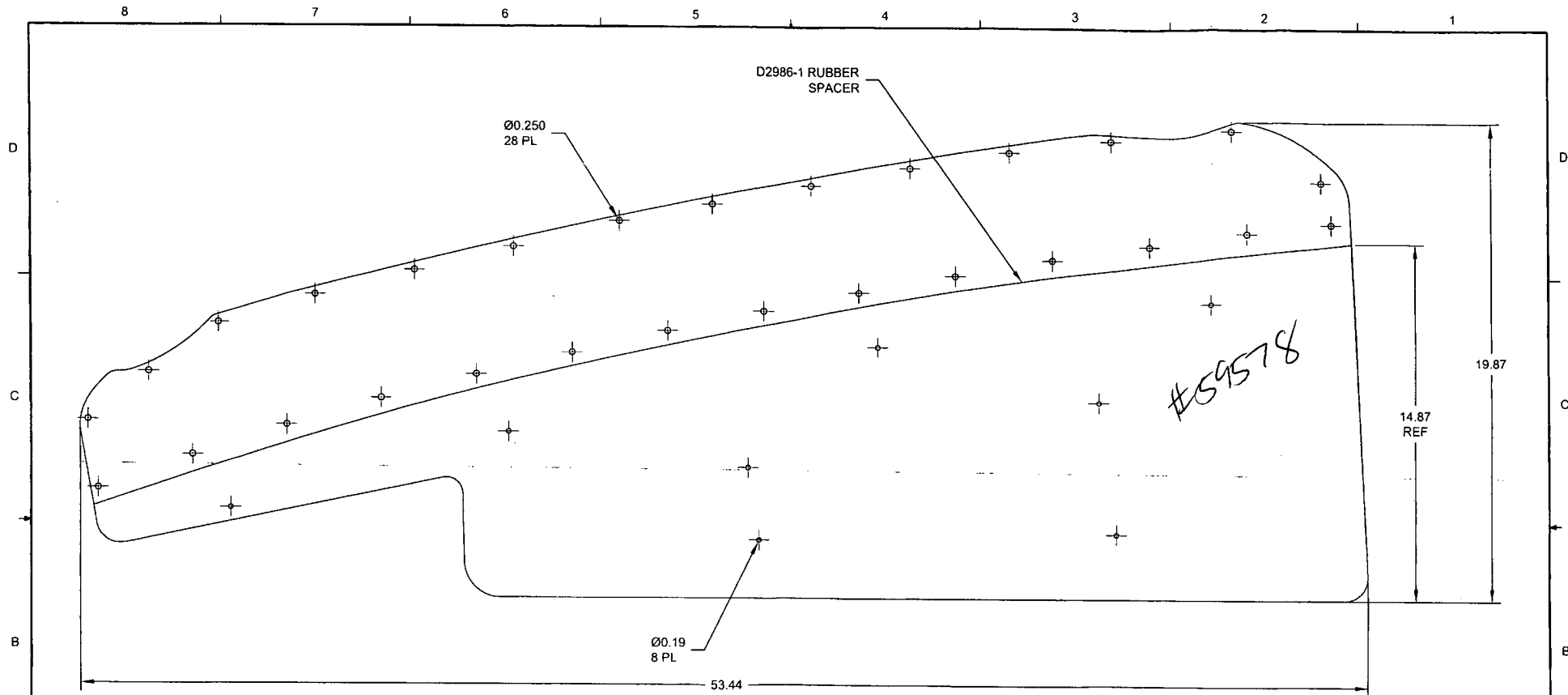
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D3187-2 SPACEPOD FLOOR

D3187-2 SPACEPOD FLOOR NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3187-2" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.2 LBS
- 8) TOOLING: CUT/DRILL PER TEMPLATE DT3187-1T1
- 9) AFTER FINISH, INSTALL D2986-1 RUBBER SPACER USING CONTACT CEMENT. TRIM TO FIT

RELEASED
09.01.05 JMB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3187	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NT
DATE	09.01.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

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